

Work Order ID 53840

November 19, 2009 11:23:19 AM

Page 1

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 19/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: B1

Date: 09/11/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2221	Rev H								

100 Large Fab 0.00



Large Fab

Large Fab Memo 0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per
 dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: MIC9213

PD 09.11.27

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

QC09/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: 350 Basket Base

Start Date: 19/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

2) S 09/11/30



QC

Quality Control

Memo

0.00

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to M112148

1ST COAT:

START TIME: 11:15

400°

OVEN TEMPERATURE:

FINISH TIME: 11:25

***** 2nd coat if necessary*****

BK 09-11-30

①

2ND COAT:

START TIME: 1:00

400°

OVEN TEMPERATURE:

FINISH TIME: 1:30

BK 09-11-30

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Start Date: 19/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

MB 09/12/01

X1

150

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

W053831 0.00

WD 09/12/01

X1

160

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

09/12/03 JF

W 09/12-2
①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 1

November 19, 2009 11:23:27 AM

Work Order ID: 53840**Parent Item:** D2221RevH**Parent Item Name:** 350 Basket Base**Start Date:** 19/11/2009**Required Date:** 25/11/2009**Comments:** ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM**Start Qty:** 1.00**Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2221-1RevH



Manufactured

No

100

Each

24.0000

1.0000



Rib

Warehouse	Loc Qty	Loc Code
------------------	----------------	-----------------

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

23

51872

1

53213

10

53662

12

RD 09.11.23

D2221-5RevH



Manufactured

No

100

Each

6.0000

2.0000



Rib

Warehouse	Loc Qty	Loc Code
------------------	----------------	-----------------

Location

Main Warehouse

ST

6

53244

6

RD 09.11.23

D2221-7RevH



Manufactured

No

100

Each

3.0000

1.0000



Rib

Warehouse	Loc Qty	Loc Code
------------------	----------------	-----------------

Location

Main Warehouse

WA

3

53246

3

RD 09.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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November 19, 2009 11:23:27 AM

Work Order ID: 53840



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	12.0000	2.0000			

Basket Hinge

Warehouse

Location

Main Warehouse

ST

2

50024

2

Main Warehouse

WA

10

53344

10

PD 09.11.26

D2235-1RevB1

Manufactured

No

100

Each

6.0000

2.0000

Basket Rib

Warehouse

Location

Main Warehouse

ST

2

53215

2

Main Warehouse

WA

4

50565

3

51871

1

53660

PD 09.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: 350 Basket Base

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No		100	Each	36.0000	2.0000				

Mounting Bracket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	12	
46086	2	
48428	1	
51120	9	

Main Warehouse

WA	24	
50872	1	
51745	23	

D3442-1RevA

Manufactured

No

100 Each 18.0000 2.0000

PD 09.11.27



Shim

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	1	
46767	1	

Main Warehouse

WA	17	
50951	5	
53386	12	

PD 09.11.26 ①
PD 09.11.26 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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November 19, 2009 11:23:27 AM

Work Order ID: 53840



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	10.0000	2.0000			

Rib Assembly (Basket End)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA

10

53381

4

53548

6

DD 09.11.23

D3826-041RevB



Manufactured

No

100

Each

8.0000 2.0000



Rib / Gusset Assembly

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

WA

8

53216

4

53500

4

DD 09.11.23

D3827-041RevA



Manufactured

No

100

Each

2.0000 1.0000



Rib Assembly (Inboard)

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

2

53247

2

53661 DD 09.11.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 53840



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 19/11/2009

Required Date: 25/11/2009

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA		Manufactured	No			100	Each	3.0000	1.0000			

Mesh (Base)

WarehouseLocation

Main Warehouse

ST

Loc QtyLoc Code

53626 PD 09.11.24

2

46306

1

46774

1

Main Warehouse

WA

1

53218

1

D3833-1RevA



Manufactured No

100

Each

12.0000 2.0000



Mesh (Base End Face)

WarehouseLocation

Main Warehouse

WA

Loc QtyLoc Code

PD 09.11.26

12

50025

2

53214

4

53627

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

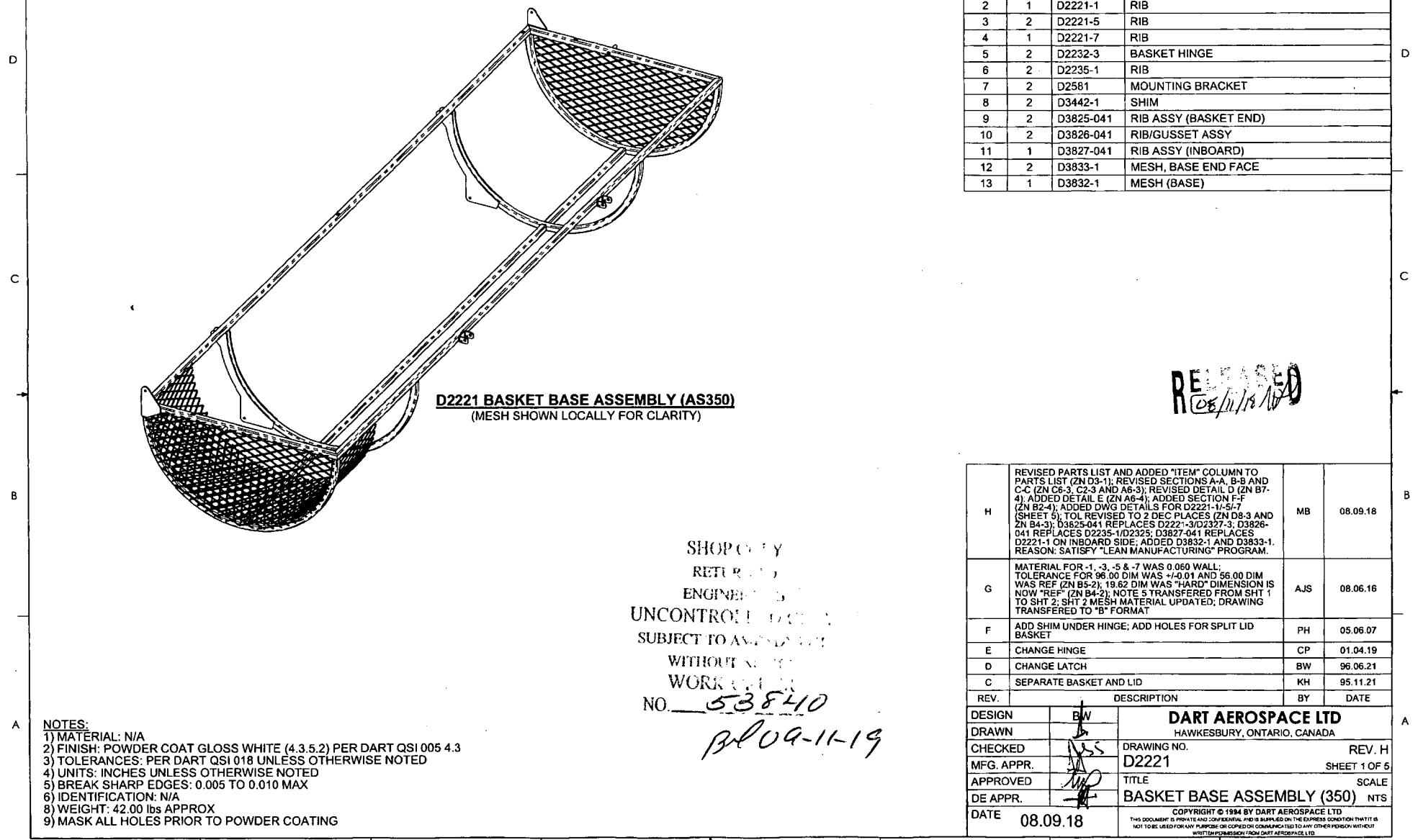
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

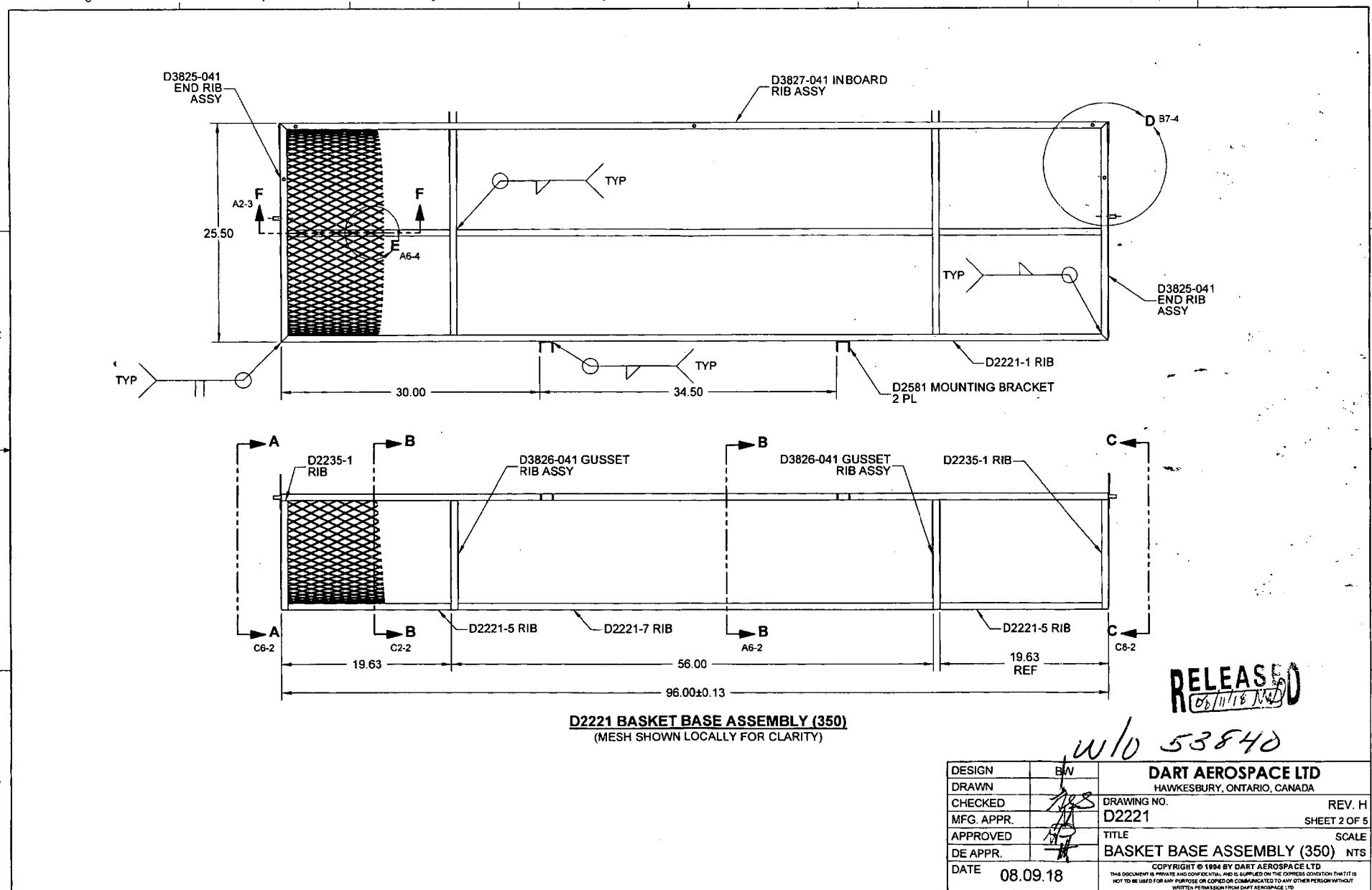
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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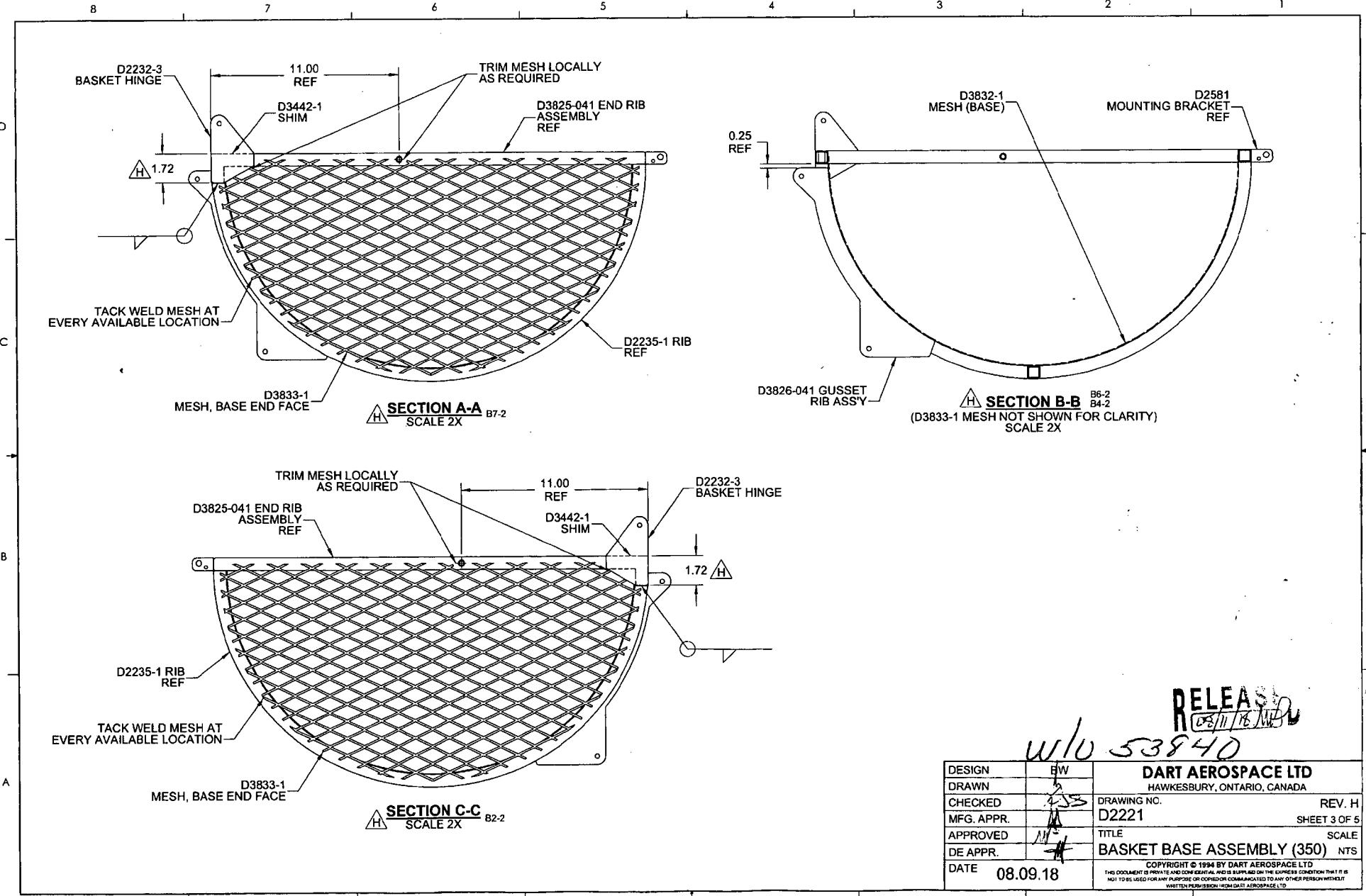
NOTE: Date & initial all entries

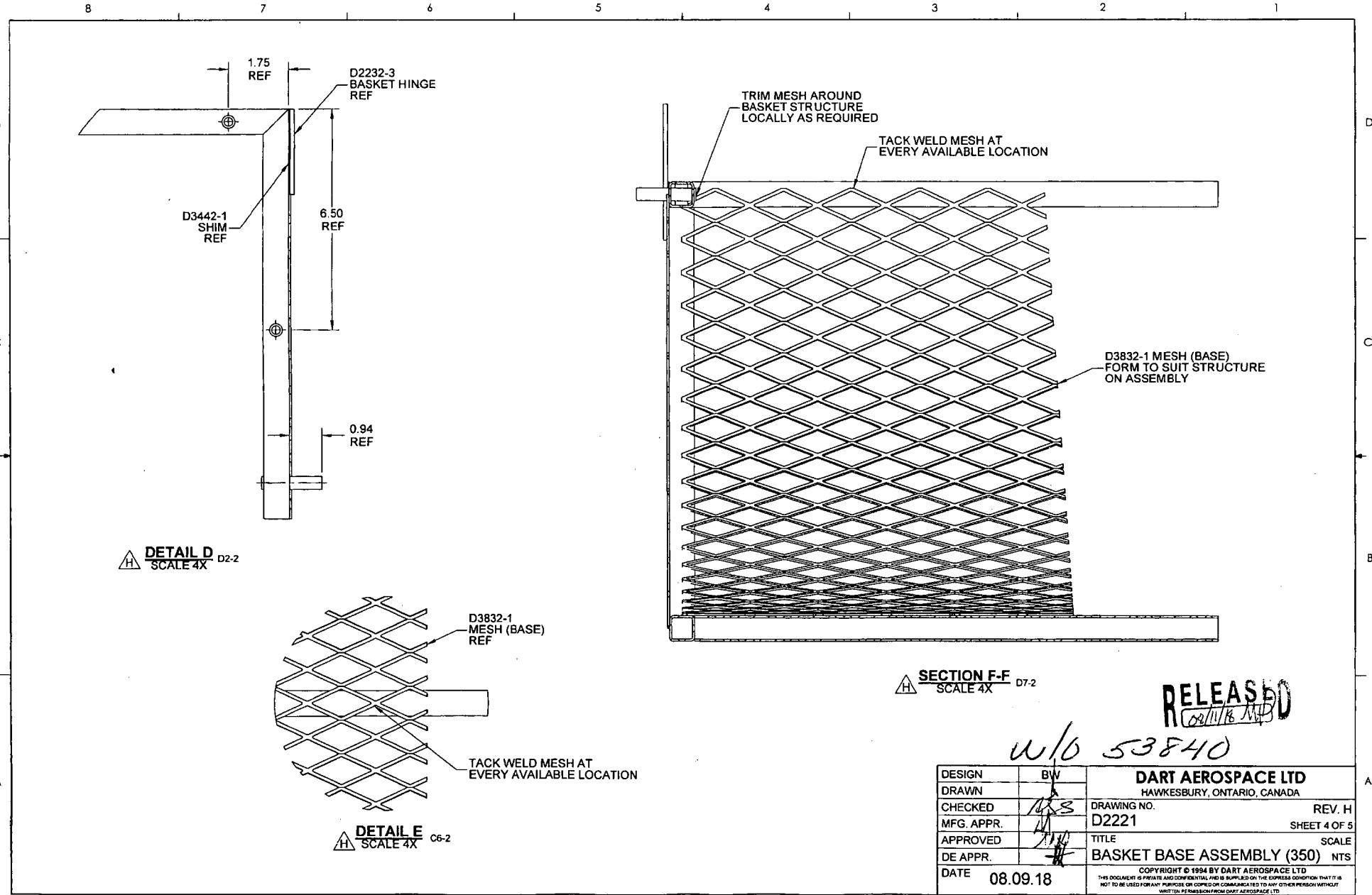
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8 7 6 5 4 3 2 1



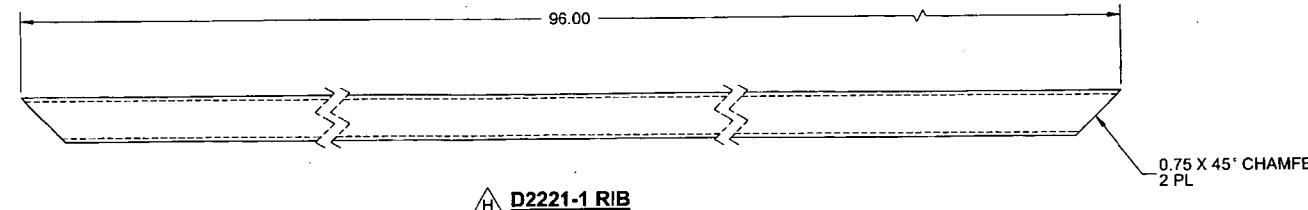
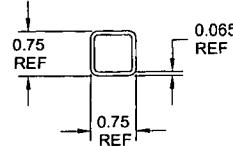




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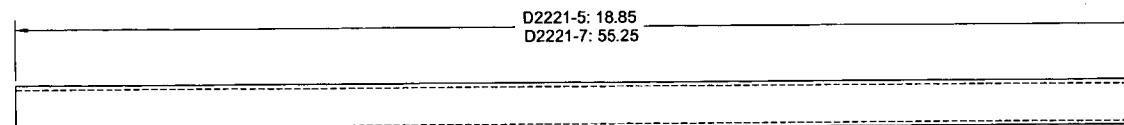
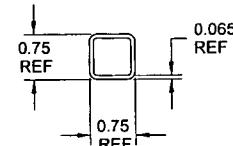
D

D



C

C



B

B

A

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.75W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED 06/11/16 W/0 53840

DESIGN	B/W	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>ADS</i>	REV. H
MFG. APPR.	<i>MD</i>	DRAWING NO. D2221 SHEET 5 OF 5
APPROVED	<i>MM</i>	TITLE
DE APPR.	<i>SH</i>	SCALE
DATE	08.09.18	BASKET BASE ASSEMBLY (350) NTS

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8 7 6 5 4 3 2 1